



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

12861

D3531-3

Job Sheet 189305



Part No: D3531-3

Job Qty: 4 pcs

Part Name: Bracket Front Plate



Part Weight: 0 lbs

Job Created: 1/22/19

Due Date: 2/12/19

Type: SOLD

SOLD
ASAP

Status: New

Priority: Medium

Job Tracking No:

Created By: Dara Macdonald

Description:

Note: DWG REV B SHEETS 4,5 IPP Rev:A New Issue 07-09-24 EC verified by DD IPP REV:B 12.10.24 PER DWG REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	4 pcs	2/12/19	2/12/19	0.00	0.26	Waterjet - Flow		ac 19/02/11
120	QC 8	4 pcs	2/12/19	2/12/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 38		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
140	Small Fab - Brake NC - B4B	4 pcs	2/12/19	2/12/19	0.03	0.38	Small Fab - Brake - 1 - B4B		
							Small Fab - Brake - 2 - B4B		
							Small Fab - Brake - 3 - B4B		
150	QC 5	4 pcs	2/12/19	2/12/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		

DAS
58 FEB 11 2019
9-89

19/02/12

					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 38	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	DAS
					QC 5 - 58	58 FEB 12 2019
					QC 5 - 68	9-89
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
160	Handfinish - 1-1 Chemical-B4B	4 pcs	2/12/19	0.00 0.21	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	D.R 19/2/13
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
170	QC 7	4 pcs	2/12/19	0.00 0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 38	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	

				QC 7 - 6	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	QC DAS 68 19/02/15
				QC 7 - 50	9-89
				QC 7 - 67	
180	Packaging 3-1 - Stock - B4B	4	2/12/19	0.00 0.00	Packaging 3 - 1 - B4B
	pcs				Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
190	QC 21 - SA	4	2/12/19	0.00 0.00	QC 21 - SA - 21
	pcs				QC 21 - SA - 70
Part Op 100 - 1-Cut as per Dwg D3531 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-Deburr if necessary Descriptions: 120 - (QC8- Inspect parts - second check) 140 - (Bend/Assemble as per dwg) 150 - (QC5- Inspect part completeness to step on W/O) 160 - (Chemical Conversion Coat per QSI005 4.1) 170 - (QC7-Inspect Chemical Conversion Coat) 180 - (Identify as per dwg & Stock Location: _____) 190 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6S.040	6061-T6 .040 Sheet	.5252 sf (.1313 ea)	100-Waterjet - Flow - 1	5152150	

Job Allocations

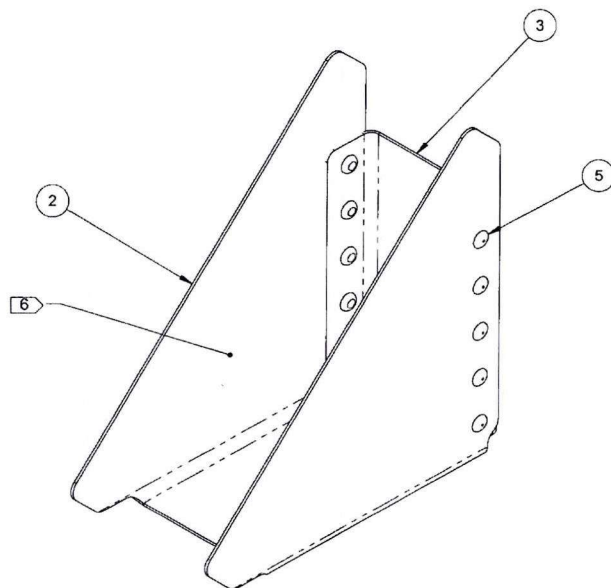
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.040	1	11	0

Part Specifications

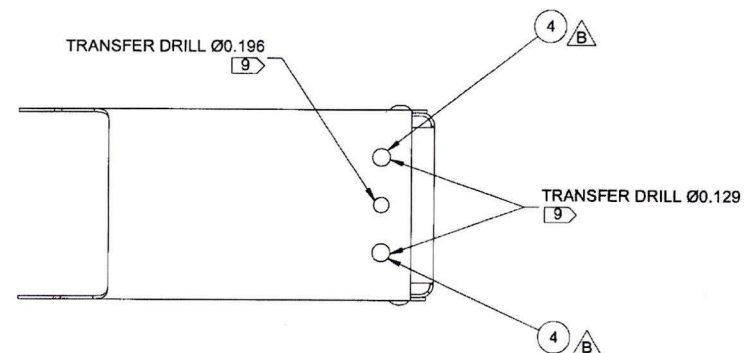
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket Front Plate	0.129Inches + 0.005 - 0.001	0.134 0.128	Diameter	
2	Bracket Front Plate	3.720Inches ± 0.030	3.750 3.690		
3	Bracket Front Plate	0.370Inches ± 0.030	0.400 0.340		
4	Bracket Front Plate	2.840Inches ± 0.010	2.850 2.830		
5	Bracket Front Plate	0.880Inches ± 0.030	0.910 0.850		
6	Bracket Front Plate	3.500Inches ± 0.030	3.530 3.470		
7	Bracket Front Plate	4.670Inches ± 0.030	4.700 4.640		

Plex 1/22/19 1:16 PM Dart.Macdonald.Dara

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3531-041	BRACKET ASSEMBLY
2	1	D3531-1	BRACKET
3	1	D3531-3	BRACKET FRONT PLATE
4	2	MS20426AD4-4	RIVET
5	10	MS20470AD4-4	RIVET



D3531-041 BRACKET ASSEMBLY



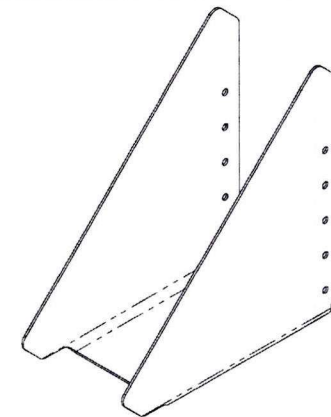
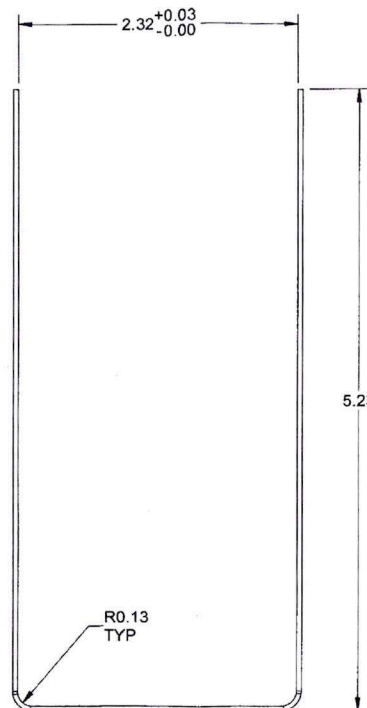
**D3531-041 BRACKET ASSEMBLY
BOTTOM VIEW**

RELEASED
12/10/13
PER ECU 12-669

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON INSIDE OF BRACKET ASSEMBLY, WHERE INDICATED
- 7) WEIGHT: 0.22 lbs
- 8) ASSEMBLE PER DART QSI 003
- 9) TRANSFER DRILL HOLES FROM D3531-1 BRACKET THROUGH D3531-3 BRACKET FRONT PLATE BEFORE FINISHING

B	CHANGE BOTTOM RIVETS FROM MS20470AD4-4 TO MS20426AD4-4, ZN C2-1, C5-3. ADD CSK, ZN C5-3, CORRECT BEND LINE DIM, ZN C4-3. UPDATE TO CURRENT DWG STANDARDS, REF PAR 10-47.	DC	12.08.09
A	NEW ISSUE	CB	07.06.19
REV.	DESCRIPTION	BY	DATE
DESIGN	C.B.		
DRAWN	DC		
CHECKED	DE		
MFG. APPR.	DE		
APPROVED	DE		
DE APPR.	DE		
DATE	12.08.09		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3531 BRACKET ASSEMBLY COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			
			REV. B SHEET 1 OF 5 SCALE NTS

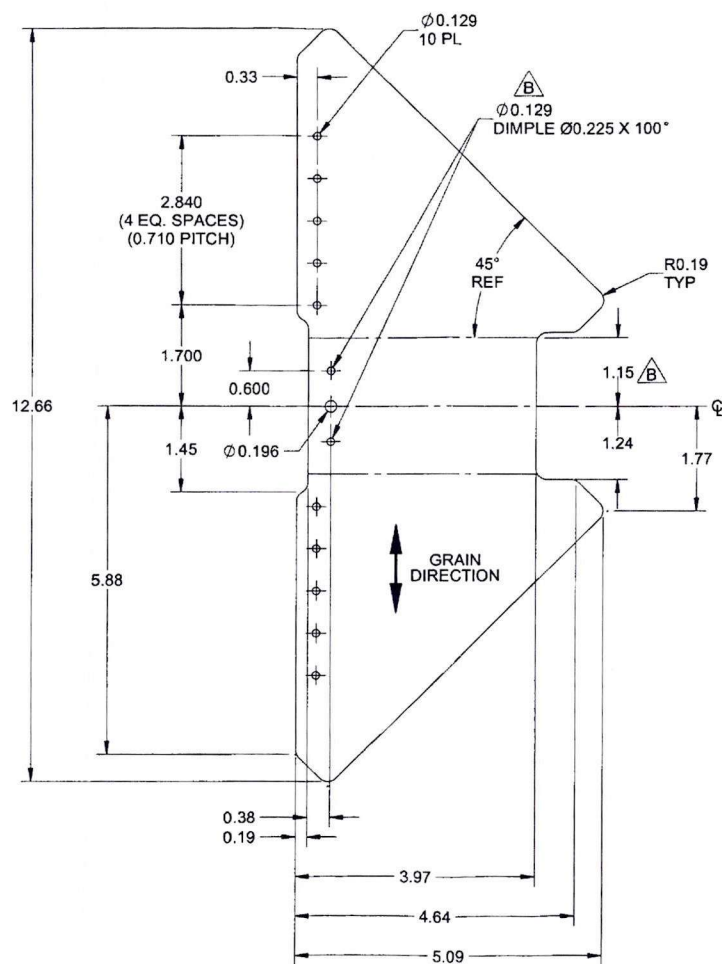


D3531-1 BRACKET

RELEASED
12/19/25

- NOTES:**
- 1) MATERIAL: MADE FROM D3531-1F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.16 lbs

DESIGN	CB	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.	AP	D3531	SHEET 2 OF 5
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	BRACKET ASSEMBLY	NTS
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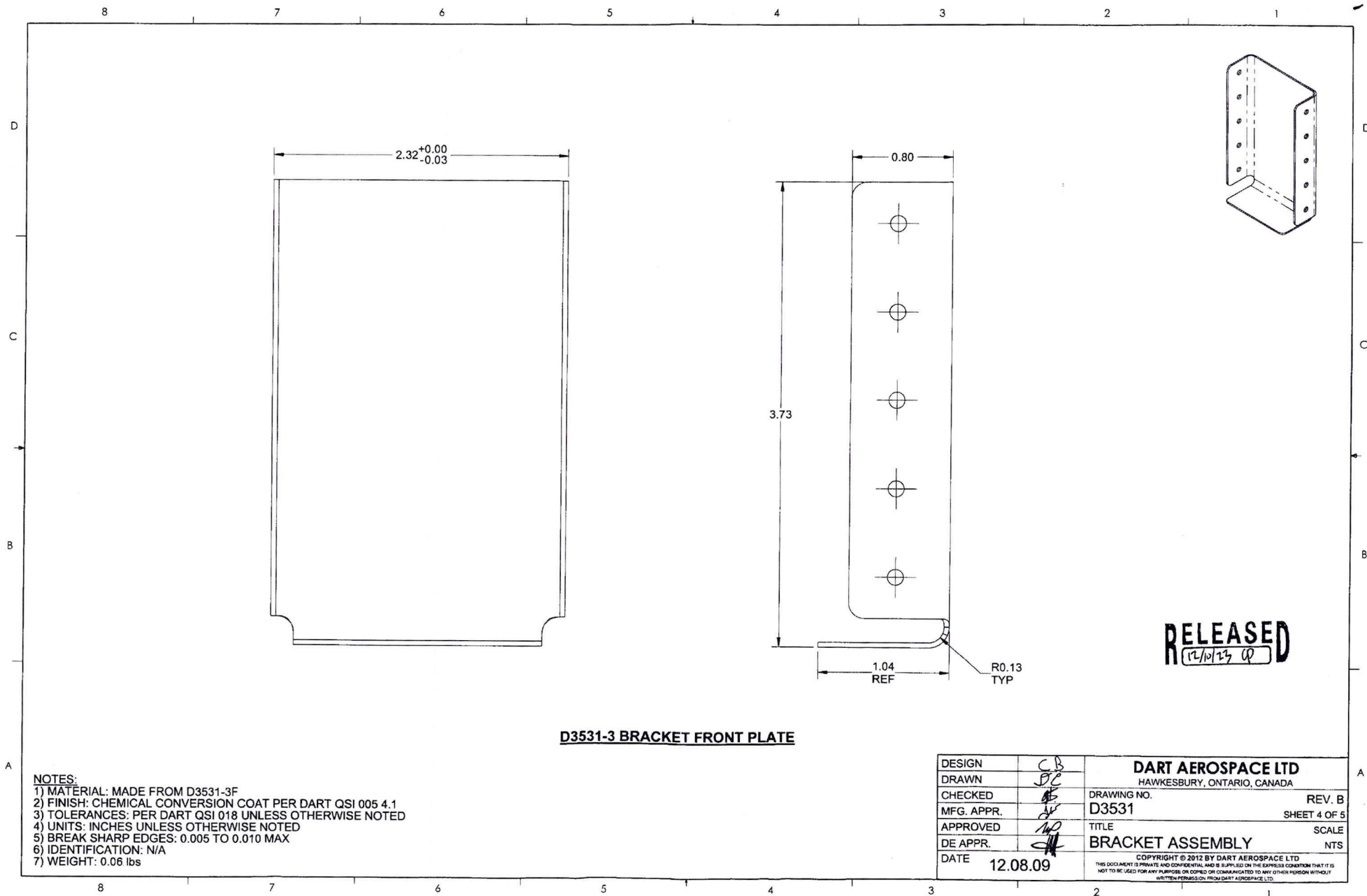
NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.16 lbs

D3531-1F FLAT PATTERN

DESIGN	CB	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JE	DRAWING NO.	REV. B
MFG. APPR.	JE	D3531	SHEET 3 OF 5
APPROVED	JE	TITLE	SCALE
DE APPR.	JE	BRACKET ASSEMBLY	NTS
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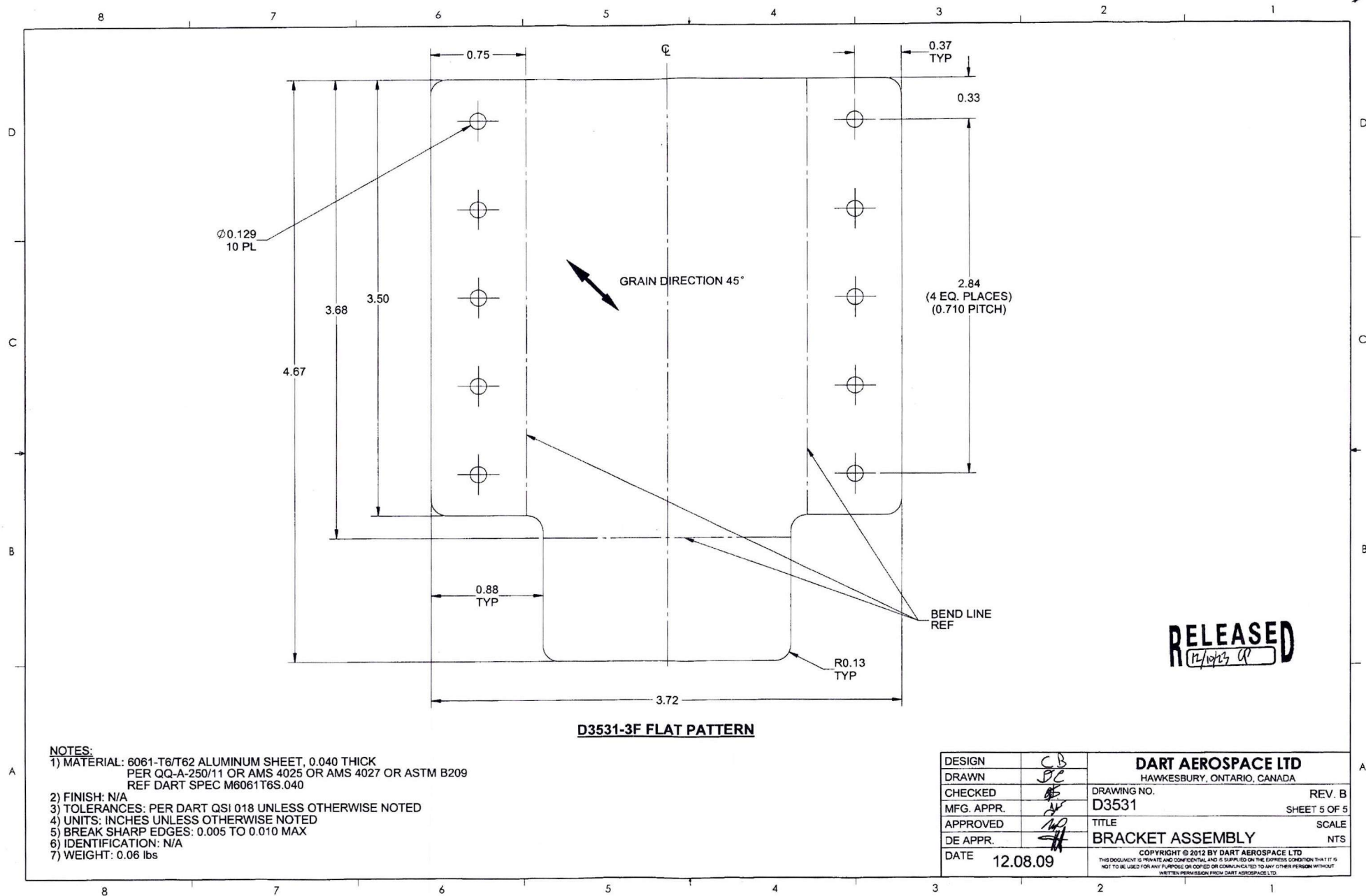
RELEASED
12/14/23 4



D3531-3 BRACKET FRONT PLATE

- NOTES:**
- 1) MATERIAL: MADE FROM D3531-3F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.06 lbs

DESIGN	CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	AE	DRAWING NO.	REV. B
MFG. APPR.	AE	D3531	SHEET 4 OF 5
APPROVED	AE	TITLE	SCALE
DE APPR.	AE	BRACKET ASSEMBLY	NTS
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NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.06 lbs

DESIGN	C.B.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	J.C.		
CHECKED	J.P.	DRAWING NO.	REV. B
MFG. APPR.	J.V.	D3531	SHEET 5 OF 5
APPROVED	J.M.	TITLE	SCALE
DE APPR.	J.H.	BRACKET ASSEMBLY	NTS
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RELEASED
12/10/23 UP

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Container No: S152423



Part: D3531-3

Job No: 189305

Serial No/Batch: S152423

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/11/19